

Work Order ID 52158

Thursday, September 17, 2009 9:21:54 AM



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Item ID: D3193-041

Revision ID: C

Item Name: Support Bracket Assembly

Start Date: 9/17/2009 Start Qty: 12.00

Required Date: 10/2/2009 Req'd Qty: 12.00

Accept

9/10/09



Setup Start



Stop



Reference:

Approvals: Process Plan:

Date: 09-9-17

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr.
D3193	Rev C

100



BAND SAW

0.00

88 09/10/09

13 0

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 3.500" x 2.500" x 5.900" long Bar

110



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA374 and Dwg D3193 Identify as D3193-1□2-Deburr and Tumble

120



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

MJ
89/10/11MJ
09/10/11

13

X

PT

Last

Page

13

X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		W/O was split for 1 per NCR	S	9/10/14	X2	AS 1027	8/11/14

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52158

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Setup

Start



Revision ID: C

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Start Date: 9/17/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 10/2/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run

Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

**Sequence ID/
Work Center ID**

130



QC

Quality Control

**Operation
Description**

QC8- Inspect parts - seconid check

**Set Up/
Run Hours**

0.00

**Draw
Number**Draw
Rev.**Plan
Code**Accept
Qty**Reject
Qty**Reject
Number**Insp.
Stamp**

13 12 0

18 09/10/14

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

24 09/10/14

0.00

12 9

Memo

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

0.00

24 09/10/15

12 6

Memo

START TIME:

7:15a

OVEN TEMPERATURE:

7:45a

FINISH TIME:

320°

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Accept



Setup Start



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Start Date: 9/17/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 10/2/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Draw
Number****Draw
Rev.****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

160



QC3- Inspect Part Finish

0.00
BL
0.00

09-10-15

12

QC

Memo

Quality Control

170



Small Fab

0.00

09-10-21 12

Small Fab

Memo

0.00

Small Fab Assemble D3193-041 as per Dwg D3193

180



QC5- Inspect part completeness to step on W/O

0.00

2) 09-10-22

12

QC

Memo

0.00

Quality Control

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Item ID: D3193-041

Accept



Setup Start



Revision ID: C

Stop



Item Name: Support Bracket Assembly

Start Date: 9/17/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 10/2/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

**Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Draw
Number****Draw
Rev.****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

190

Identify as per dwg & Stock Location: 180

0.00

9/10/23 12k sf

Packaging

Memo

0.00

200



QC21- Final Inspection - Work Order Release

0.00

10.09.27

QC

Memo

0.00

Quality Control

MF
09-10-23

Picklist Print

Page 1

Thursday, September 17, 2009 9:21:53 AM

Work Order ID: 52158



Parent Item: D3193-041RevC



Parent Item Name: Support Bracket Assembly

Start Date: 9/17/2009

Required Date: 10/2/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21073L4		Purchased		No		100	Each	76.0000	48.0000			

NUTPLATE

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	<u>Warehouse</u>		<u>Loc Qty</u>	<u>Loc Code</u>	<i>103363</i> <i>SEL</i>
								<u>Location</u>				
MS6061T6B2.500X03.50 0		Purchased		No		170	f	ST	76			
6061-T6 Bar 2.50 x 3.50								103693	26			
								112679	50			

6061-T6 Bar 2.50 x 3.50

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	<u>Warehouse</u>		<u>Loc Qty</u>	<u>Loc Code</u>	<i>6'</i>
								<u>Location</u>				
MS20426AD3-7		Purchased		No		170	Each	ST	29.47			
RIVET								102838	13.1			
								110936	1.03			
								111700	15.34			

MS20426AD3-7



RIVET

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	<u>Warehouse</u>		<u>Loc Qty</u>	<u>Loc Code</u>	<i>17964</i> <i>9/10/19</i> <i>624</i> <i>SL</i>
								<u>Location</u>				
								ST	9091			
								17694	9091			

DART AEROSPACE LTD		Work Order:	52158
Description: Support Bracket		Part Number:	D3193-1
Inspection Dwg: D3193 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.435	+/-0.010	3.435	✓			
2.012	+/-0.010	2.010	✓			
1.200	+/-0.010	1.200	✓			
2.006	+/-0.010	2.005	✓			
R0.125	+/-0.010					
2.435	+/-0.005	2.436	✓			
0.281	+/-0.005	0.281	✓			
0.264	+/-0.010	0.261	✓			
5.878	+/-0.010	5.878	✓			
4.878	+/-0.005	4.879	✓			
2.550	+/-0.010	2.548	✓			
15°	+/-0.5°					
0.260	+/-0.010	0.260	✓			
R0.05	+/-0.030					
Ø0.266	+0.006/-0.001	Ø0.268	✓			
Ø0.098	+0.004/-0.001	Ø0.101	✓			
Ø0.180 x 100°	+0.005/-0.001	177	✓			
0.850	+/-0.010	0.855				
R0.125	+/-0.010					
0.255	+/-0.010	0.255	✓			
2.812	+/-0.010	2.811	✓			

Measured by: *JK*
Date: *09/10/14*

Audited by: *JK*
Date: *09/10/14*

Prototype Approval: N/A
Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue P/O D3193-041	KJ/DD	<i>JK</i>
B	09.05.04	R0.50 was R0.050	KJ/DD	<i>JK</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3193-041 → D206-667-011 PAR #: N/A Fault Category: Mach. NCR: Yes No DQA: H Date: 09.10.27
 Resolution: Accepted. Disposition: use as is. QA: N/C Closed: J Date: 09.10.28

NCR: 52158		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/10/14	X 10	center pocket of part are not centered because offset was put on long way (ONE WALL IS 0.245 (0.260 Nom)) Drop pocket 10A.	GP 09.10.14 pc 09/04/14	scrap and rework PART ACCEPTABLE. CENTER POCKET OFFSET, TOTAL SECTION MAINTAINED.	MWT 09/10/14	S 09/10/14	GP 09.10.14 pc 09/04/14	S 09/10/14

NOTE: Date & initial all entries